

The Right Tool at the Right Time



High Performance Solid Carbide Deep Hole Drills,

for depths up to 30 x Diameter



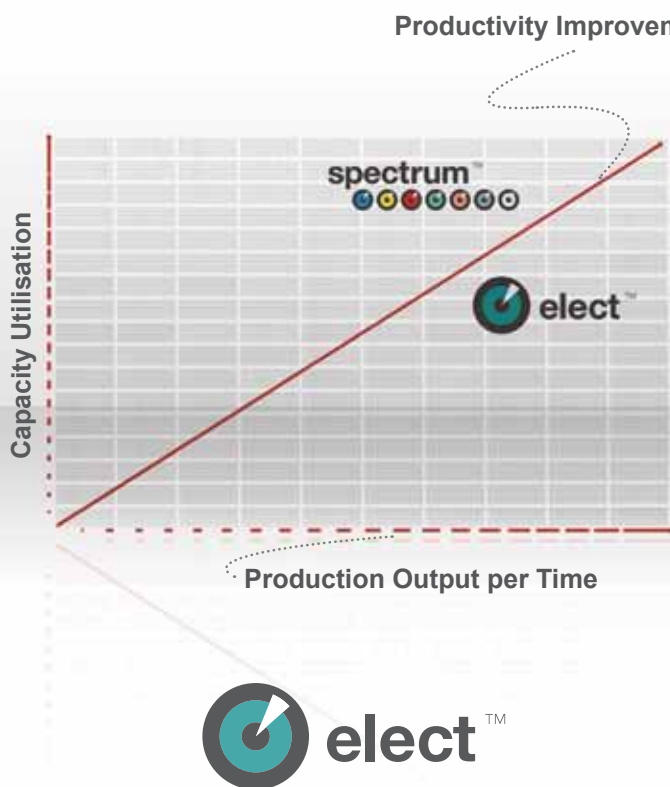
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Your Productivity *Our Vision*

At Dormer, we understand that each customer is different. One customer's priority may be to maximise capacity utilisation, whilst another's may be to increase production output per time.

To help our customers choose the tool that best meets their requirements, Dormer classifies its rotary tooling ranges under one of the following two productivity classes:



	spectrum	elect P	elect M	elect K	elect N	elect S	elect H	elect O
Steel	●	●						
Stainless Steel			●					
Cast Iron				●				
Non ferrous material					●			
Heat resistant super alloys						●		
Hardened Materials							●	
Other								●



Products carrying the **Elect™** brand identify Dormer's best performing tools for one specific material or application, satisfying the need for high output per time.

In the case of material specific tools, a letter, relating to the **ISO** material classifications, will be added to the brand mark to denote material suitability e.g. **Elect P™** denotes that this is a top performing tool for steel. In the case of application specific tools (e.g. deep hole drills or thread milling cutters) the term "APP" will be used to form the brand mark **Elect APP™**.

Tools carrying the **Spectrum™** brand indicate excellent productivity over a multitude of materials, providing high capacity utilisation and versatility.

The brand mark incorporates a visual reference to every **ISO** material colour code, denoting that these products are suitable for a range of applications or material types.

Features & Benefits

Material

Micrograin carbide.

Surface Treatment

Dormer's proprietary Super-Flow coating has been specifically developed to optimise performance of the Elect APP™ drills for deep holes, offering:

- A smooth surface to assist chip evacuation
- Greater stability of cutting edges
- Outstanding wear resistance
- High hardness and toughness properties and oxidation stability
- Exceptional chip evacuation capabilities in all recommended materials, even at drilling depths of 30 x Ø
- Significantly increased tool life and productivity

The R570 (8 x Ø) and R571 (12 x Ø) drills are coated along the entire length of the flute. For drills above 12 x Ø, the Super-Flow coating is applied to the drill tip followed by a unique finishing treatment, to facilitate chip evacuation at greater depths and also to reduce torque.

ACM™ (Advanced Chip Management) Flute Geometry

Dormer's proven ACM™ (Advanced Chip Management) flute geometry promotes ample flute volume along the length of the drill and encourages the formation of small, manageable chips, ensuring efficient chip evacuation in deep hole drilling applications. In addition, ACM™ ensures consistent forces throughout the drilling cycle for even tool wear and therefore prolonged tool life.

Point Geometry

Specially designed point helps to reduce thrust forces and provides clearance for the high feeds recommended on Elect APP™ drill ranges for deep holes.

Edge Preparation

The consistent edge preparation on Elect APP™ drills for deep holes protects the cutting edges from premature chipping and flaking, with subsequent benefits to tool life.

Double offset margins

Dormer's patented double offset margins on diameters of 5mm and above offer greater stability to the drilling operation, reducing chatter and improving hole concentricity (R572, R573, R575).

Internal Coolant

Internal coolant holes deliver cutting fluid directly to the tip of the drill, cooling the cutting area and efficiently evacuating chips away from the hole. This allows for high speeds and feeds, resulting in high productivity and lower cost per hole.



Shank

To DIN 6535 HA.

Hole Depth

Drilling depths up to $30 \times \varnothing$ are achievable without the need for pecking throughout the full diameter range. For depths of $>12 \times \varnothing$ to $30 \times \varnothing$, a complementary solid carbide pilot drill (R470) with 150° point angle has been developed for pre-drilling to a maximum depth of $3 \times \varnothing$ (minimum recommended depth $1.5 \times \varnothing$). This enables greater accuracy in drill location and minimal hole run out when drilling deep holes.

Regrinding

All Elect APP™ drills for deep holes can be reground and recoated at a Dormer regrinding centre, in order to provide repeatable tool performance.

Range

R570 ($8 \times \varnothing$), 3.0 – 20.0mm and $1/8''$ – $5/8''$
R571 ($12 \times \varnothing$), 3.0 – 20.0mm and $1/8''$ – $21/32''$
R572 ($15 \times \varnothing$), 3.0 – 12.0mm and $1/8''$ – $29/64''$
R573 ($20 \times \varnothing$), 3.0 – 12.0mm and $1/8''$ – $29/64''$
R575 ($30 \times \varnothing$), 3.0 – 8.0mm and $1/8''$ – $5/16''$

R470 pilot drill, 3.0 – 12.0mm and $1/8''$ – $29/64''$
(for pilot drilling $>12 \times \varnothing$ to $30 \times \varnothing$).

Tool Holding

The Elect APP™ drill ranges for deep holes are designed to be used with a high precision chuck such as Dormer HydroGrip®, for optimum hole quality and minimum run out.

Application Methods

The Elect APP™ drills for deep holes have proven application methods for cross hole and angled face drilling. Speeds and feeds recommended for use with these applications are a starting point and may be modified to increase productivity, taking into consideration all other elements in the machining process - machine tool, tool holder, workpiece and clamping system.



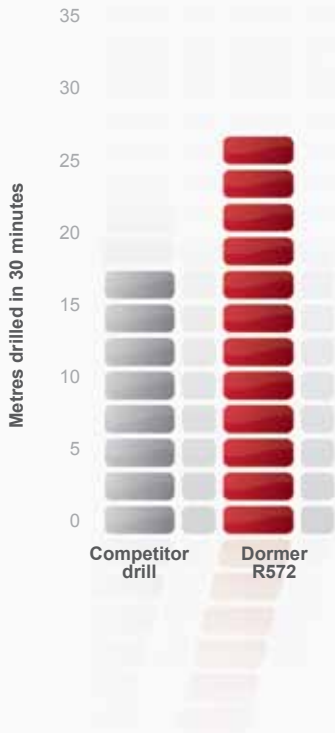
Customer *Benefits*

- Accurate deep holes to depths up to 30 x Ø without the need for pecking.
- High speeds and feeds allow greater productivity and therefore lower cost per hole.
- Fast and efficient chip evacuation reduces machine downtime and increases tool life.
- Consistent forces throughout the drilling cycle ensure a **stable drilling operation**, resulting in negligible chatter and improved hole concentricity.
- Enhanced centring capabilities.
- Internal coolant holes ensure a reduction of heat generated in the cutting zone for **trouble-free machining** and excellent chip management.
- Honed cutting edges prevent premature chipping or flaking and result in **increased tool life**.
- Reduced torque, reduced thrust forces.
- Designed to be reconditioned to further extend tool life.
- Pilot drilling technique on drilling depths of >12 x Ø, to achieve greater accuracy and minimal hole run out.
- Proven application methods for cross hole drilling and angled face drilling.



Field Test

R572, Elect APP™ drill, 15 x D



Customer: Die & mould industry, Sweden
Application: Horizontal drilling operation
Target: To increase productivity
Material: DIN 1.2344, ESR (AMG 1.4), and Orvar Supreme (AMG 1.5)

Drill Diameter: 10.3mm
Drilling depth: 140mm

Cutting Conditions: (Dormer drill)
Vc: 90m/min, 2781rpm
Vf: 0.33mm/rev, 917mm/min

Cutting Conditions: (Competitor drill)
Vc: 55m/min, 1700rpm
Vf: 0.33mm/rev, 561mm/min

Tool life: 30 minutes
Pilot drill: Dormer pilot drill 10.3mm to a depth of 15mm

Coolant pressure: 80 bar

Result

The Dormer R572 Elect APP™ drill and the competitor drill were used in a horizontal application to drill to a depth of 140mm at manufacturers' recommended cutting conditions. As the graph shows, productivity of the Dormer R572 Elect APP™ drill is more than 60% higher than that of the competitor drill, measured in metres drilled in 30 minutes.

Application Material Groups

■ Excellent for Application


● Good for Application

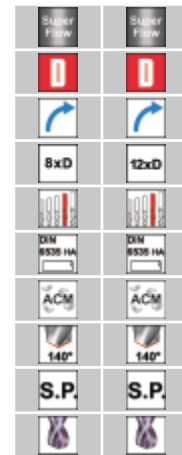
(see pages 10 - 17)

Example

130 = Peripheral speed in metres/minute +/- 10%

V = Feed - see feed table

 Fn	3mm	4mm	5mm	6mm	8mm	10mm	12mm	15mm	16mm	20mm
U	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240
V	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340
W	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450
X	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580
mm/N +/- 25%										

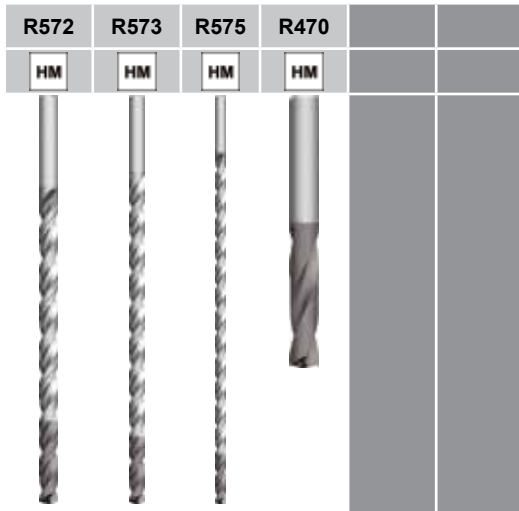

















3.00 - 20.00 3.00 - 20.00

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Application Material Groups (AMG)		Hardness HB	Tensile Strength N/mm ²	10	12
1. Steel	1.1 Magnetic soft steel	<120	<400	130V	130V
	1.2 Structural Steel / case carburising steel	<200	<700	120V	120V
	1.3 Plain Carbon steel	<250	<850	110V	110V
	1.4 Alloy steel	<250	<850	100W	100W
	1.5 Alloy steel/ Hardened and tempered steel	>250 <350	>850 <1200	90W	90W
	1.6 Alloy steel/ Hardened and tempered steel	>350	>1200 <1620	80V	80V
	1.7 Alloy steel Hardened	49-55HRC	>1620		
	1.8 Alloy steel Hardened	55-63HRC	<1960		
2. Stainless Steel	2.1 Free machining Stainless Steel	<250	<850	35V	35V
	2.2 Austenitic	<320	<1100	30V	30V
	2.3 Ferritic + Austenitic, Martensitic	<300	<1000	25V	25V
	2.4 Precipitation Hardened	>320 <410	>1100 <1400	25U	25U
3. Cast Iron	3.1 Lamellar graphite	<150	<500	115W	115W
	3.2 Lamellar graphite	>150 <300	>500 <1000	115W	115W
	3.3 Nodular graphite/ Malleable Cast Iron	<200	<700	75V	75V
	3.4 Nodular graphite/ Malleable Cast Iron	>200 <300	>700 <1000	75V	75V
4. Titanium	4.1 Titanium, unalloyed	<200	<700		
	4.2 Titanium, alloyed	<270	<900		
	4.3 Titanium, alloyed	>270 <350	>900 <1250		
5. Nickel	5.1 Nickel, unalloyed	<150	<500		
	5.2 Nickel, alloyed	<270	<900		
	5.3 Nickel, alloyed	>270 <350	>900 <1200		
6. Copper	6.1 Copper	<100	<350	125V	125V
	6.2 β-Brass, Bronze	<200	<700	220V	220V
	6.3 α-Brass	<200	<700	220V	220V
	6.4 High Strength Bronze	<470	<1500	100U	100U
7. Aluminium Magnesium	7.1 Al, Mg, unalloyed	<100	<350	270X	270X
	7.2 Al alloyed, Si<0.5%	<150	<500	270X	270X
	7.3 Al alloyed, Si>0.5%<10%	<120	<400	180W	180W
	7.4 Al alloyed, Si>10% Whisker reinforced Al-alloys, Mg alloys	<120	<400	90W	90W
8. Synthetic Materials	8.1 Thermoplastics	---	---		
	8.2 Thermosetting plastics	---	---		
	8.3 Reinforced plastic materials	---	---		
9. Hard Materials	9.1 Cermets (Metal-ceramics)	<550	<1700		
10. Graphite	10.1 Standard graphite	---	<100		



Super Flow	Super Flow	Super Flow	TAIN
			DIN 8537 K
			
15xD	20xD	30xD	3xD
			
DIN 8536 HA	DIN 8536 HA	DIN 8536 HA	DIN 8536 HA
ACM	ACM	ACM	
140°	140°	140°	150°
S.P.	S.P.	S.P.	
			
3.00 - 12.00	3.00 - 12.00	3.00 - 8.00	3.00 - 12.00

NEW 2010.09	NEW 2010.09	NEW 2010.09	NEW 2010.09	AMG	ISO
14	15	16	17		
130V	117U	117U	125W	1.1	P
120V	108U	108U	115W	1.2	P
110V	99U	99U	110W	1.3	P
100W	90V	90V	95V	1.4	P
90W	81V	81V	75V	1.5	P
80V	72U	72U	65U	1.6	P
				1.7	H
				1.8	H
35V	32U	32U	55V	2.1	M
30V	27U	27U	35V	2.2	M
25V	23U	23U	30U	2.3	M
25U	23T	23T	30U	2.4	M
115W	104V	104V	110W	3.1	K
115W	104V	104V	110W	3.2	K
75V	68U	68U	80V	3.3	K
75V	68U	68U	80V	3.4	K
			55V	4.1	S
			45V	4.2	S
			40U	4.3	S
				5.1	S
				5.2	S
				5.3	S
			125W	6.1	N
			220W	6.2	N
			220W	6.3	N
			100V	6.4	N
270X	243W	243W	250W	7.1	N
270X	243W	243W	250W	7.2	N
180W	162V	162V	200V	7.3	N
90W	81V	81V	150V	7.4	N
				8.1	O
				8.2	O
				8.3	O
				9.1	H
				10.1	O

R570

- Elect APP™ Drill for deep holes
- Elect APP™-Tieflochbohrer
- Elect APP™ diepgatboren
- Foret Elect APP™ pour trous profonds
- Broca Elect APP™ para agujeros profundos
- Broca Elect APP™ para furos profundos



R570



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 6.1 6.2 6.3 6.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
	3.00	0.1181	37	79	36	6	R5703.0
	3.10	0.1220	37	79	36	6	R5703.1
1/8	3.18	0.1250	37	79	36	6	R5701/8
	3.20	0.1260	37	79	36	6	R5703.2
	3.30	0.1299	37	79	36	6	R5703.3
	3.40	0.1339	37	79	36	6	R5703.4
	3.50	0.1378	37	79	36	6	R5703.5
9/64	3.57	0.1406	37	79	36	6	R5709/64
	3.70	0.1457	37	79	36	6	R5703.7
	3.80	0.1496	48	90	36	6	R5703.8
5/32	3.97	0.1563	48	90	36	6	R5705/32
	4.00	0.1575	48	90	36	6	R5704.0
	4.10	0.1614	48	90	36	6	R5704.1
	4.20	0.1654	48	90	36	6	R5704.2
	4.30	0.1693	48	90	36	6	R5704.3
11/64	4.37	0.1719	48	90	36	6	R57011/64
	4.50	0.1772	48	90	36	6	R5704.5
	4.60	0.1811	48	90	36	6	R5704.6
	4.70	0.1850	62	104	36	6	R5704.7
3/16	4.76	0.1875	62	104	36	6	R5703/16
	4.80	0.1890	62	104	36	6	R5704.8
	5.00	0.1969	62	104	36	6	R5705.0
	5.10	0.2008	62	104	36	6	R5705.1
13/64	5.16	0.2031	62	104	36	6	R57013/64
	5.20	0.2047	62	104	36	6	R5705.2
	5.50	0.2165	62	104	36	6	R5705.5
7/32	5.56	0.2188	62	104	36	6	R5707/32
	5.70	0.2244	62	104	36	6	R5705.7
	5.80	0.2283	62	104	36	6	R5705.8
15/64	5.95	0.2344	62	104	36	6	R57015/64
	6.00	0.2362	62	104	36	6	R5706.0
	6.10	0.2402	84	126	36	8	R5706.1
	6.20	0.2441	84	126	36	8	R5706.2
1/4	6.35	0.2500	84	126	36	8	R5701/4
	6.50	0.2559	84	126	36	8	R5706.5
	6.60	0.2598	84	126	36	8	R5706.6
	6.70	0.2638	84	126	36	8	R5706.7
17/64	6.75	0.2656	84	126	36	8	R57017/64
	6.80	0.2677	84	126	36	8	R5706.8
	6.90	0.2717	84	126	36	8	R5706.9

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
	7.00	0.2756	84	126	36	8	R5707.0
9/32	7.14	0.2812	84	126	36	8	R5709/32
	7.20	0.2835	84	126	36	8	R5707.2
	7.40	0.2913	84	126	36	8	R5707.4
	7.50	0.2953	84	126	36	8	R5707.5
19/64	7.54	0.2969	84	126	36	8	R57019/64
	7.60	0.2992	84	126	36	8	R5707.6
	7.70	0.3031	84	126	36	8	R5707.7
	7.80	0.3071	84	126	36	8	R5707.8
5/16	7.94	0.3125	84	126	36	8	R5705/16
	8.00	0.3150	84	126	36	8	R5708.0
	8.10	0.3189	106	152	40	10	R5708.1
	8.20	0.3228	106	152	40	10	R5708.2
21/64	8.33	0.3281	106	152	40	10	R57021/64
	8.40	0.3307	106	152	40	10	R5708.4
	8.50	0.3346	106	152	40	10	R5708.5
	8.60	0.3386	106	152	40	10	R5708.6
	8.70	0.3425	106	152	40	10	R5708.7
11/32	8.73	0.3437	106	152	40	10	R57011/32
	8.80	0.3465	106	152	40	10	R5708.8
	9.00	0.3543	106	152	40	10	R5709.0
23/64	9.13	0.3594	106	152	40	10	R57023/64
	9.30	0.3661	106	152	40	10	R5709.3
	9.50	0.3740	106	152	40	10	R5709.5
3/8	9.53	0.3752	106	152	40	10	R5703/8
	9.80	0.3858	106	152	40	10	R5709.8
	9.90	0.3898	106	152	40	10	R5709.9
25/64	9.92	0.3906	106	152	40	10	R57025/64
	10.00	0.3937	106	152	40	10	R57010.0
	10.20	0.4016	128	180	45	12	R57010.2
	10.30	0.4055	128	180	45	12	R57010.3
13/32	10.32	0.4063	128	180	45	12	R57013/32
	10.40	0.4094	128	180	45	12	R57010.4
	10.50	0.4134	128	180	45	12	R57010.5
27/64	10.72	0.4219	128	180	45	12	R57027/64
	11.00	0.4331	128	180	45	12	R57011.0
7/16	11.11	0.4375	128	180	45	12	R5707/16
	11.20	0.4409	128	180	45	12	R57011.2
	11.50	0.4528	128	180	45	12	R57011.5
29/64	11.51	0.4531	128	180	45	12	R57029/64

R570

d_1 Øm7 Inch	d_1 Øm ₇ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø mm	e-Code	d_1 Øm7 Inch	d_1 Øm ₇ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø mm	e-Code
	11.80	0.4646	128	180	45	12	R57011.8		14.50	0.5709	172	227	48	16	R57014.5
15/32	11.91	0.4687	128	180	45	12	R57015/32	37/64	14.68	0.5781	172	227	48	16	R57037/64
	12.00	0.4724	128	180	45	12	R57012.0		14.70	0.5787	172	227	48	16	R57014.7
	12.20	0.4803	151	202	48	14	R57012.2		15.00	0.5906	172	227	48	16	R57015.0
31/64	12.30	0.4844	151	202	48	14	R57031/64	19/32	15.08	0.5937	172	227	48	16	R57019/32
	12.50	0.4921	151	202	48	14	R57012.5		15.10	0.5945	172	227	48	16	R57015.1
1/2	12.70	0.5000	151	202	48	14	R5701/2	39/64	15.48	0.6094	172	227	48	16	R57039/64
	12.80	0.5039	151	202	48	14	R57012.8		15.50	0.6102	172	227	48	16	R57015.5
	13.00	0.5118	151	202	48	14	R57013.0		15.70	0.6181	172	227	48	16	R57015.7
33/64	13.10	0.5156	151	202	48	14	R57033/64	5/8	15.88	0.6250	172	227	48	16	R5705/8
17/32	13.49	0.5313	151	202	48	14	R57017/32		16.00	0.6299	172	227	48	16	R57016.0
	13.50	0.5315	151	202	48	14	R57013.5		17.00	0.6693	194	246	48	18	R57017.0
	13.70	0.5394	151	202	48	14	R57013.7		17.50	0.6890	194	246	48	18	R57017.5
35/64	13.89	0.5469	151	202	48	14	R57035/64		18.00	0.7087	194	246	48	18	R57018.0
	14.00	0.5512	151	202	48	14	R57014.0		18.50	0.7283	215	269	50	20	R57018.5
	14.20	0.5591	172	227	48	16	R57014.2		19.00	0.7480	215	269	50	20	R57019.0
	14.25	0.5610	172	227	48	16	R57014.25		19.50	0.7677	215	269	50	20	R57019.5
9/16	14.29	0.5625	172	227	48	16	R5709/16		20.00	0.7874	215	269	50	20	R57020.0

R571

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R571



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 6.1 6.2 6.3 6.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
	3.00	0.1181	52	94	36	6	R5713.0
	3.10	0.1220	52	94	36	6	R5713.1
1/8	3.17	0.1250	52	94	36	6	R5711/8
	3.20	0.1260	52	94	36	6	R5713.2
	3.30	0.1299	52	94	36	6	R5713.3
	3.40	0.1339	52	94	36	6	R5713.4
	3.50	0.1378	52	94	36	6	R5713.5
9/64	3.57	0.1406	52	94	36	6	R5719/64
	3.70	0.1457	52	94	36	6	R5713.7
	3.80	0.1496	67	109	36	6	R5713.8
5/32	3.97	0.1563	67	109	36	6	R5715/32
	4.00	0.1575	67	109	36	6	R5714.0
	4.10	0.1614	67	109	36	6	R5714.1
	4.20	0.1654	67	109	36	6	R5714.2
	4.30	0.1693	67	109	36	6	R5714.3
11/64	4.37	0.1719	67	109	36	6	R57111/64
	4.50	0.1772	67	109	36	6	R5714.5
	4.60	0.1811	67	109	36	6	R5714.6
3/16	4.76	0.1875	86	128	36	6	R5713/16
	4.80	0.1890	86	128	36	6	R5714.8
	5.00	0.1969	86	128	36	6	R5715.0
	5.10	0.2008	86	128	36	6	R5715.1
13/64	5.16	0.2031	86	128	36	6	R57113/64
	5.20	0.2047	86	128	36	6	R5715.2
	5.50	0.2165	86	128	36	6	R5715.5
7/32	5.56	0.2188	86	128	36	6	R5717/32
	5.80	0.2283	86	128	36	6	R5715.8
15/64	5.95	0.2344	86	128	36	6	R57115/64
	6.00	0.2362	86	128	36	6	R5716.0
	6.10	0.2402	116	158	36	8	R5716.1
	6.20	0.2441	116	158	36	8	R5716.2
	6.30	0.2480	116	158	36	8	R5716.3
1/4	6.35	0.2500	116	158	36	8	R5711/4
	6.50	0.2559	116	158	36	8	R5716.5
	6.60	0.2598	116	158	36	8	R5716.6
	6.70	0.2638	116	158	36	8	R5716.7
17/64	6.75	0.2656	116	158	36	8	R57117/64
	6.80	0.2677	116	158	36	8	R5716.8
	6.90	0.2717	116	158	36	8	R5716.9
	7.00	0.2756	116	158	36	8	R5717.0

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
9/32	7.14	0.2813	116	158	36	8	R5719/32
	7.40	0.2913	116	158	36	8	R5717.4
	7.50	0.2953	116	158	36	8	R5717.5
19/64	7.54	0.2969	116	158	36	8	R57119/64
	7.60	0.2992	116	158	36	8	R5717.6
	7.70	0.3031	116	158	36	8	R5717.7
	7.80	0.3071	116	158	36	8	R5717.8
5/16	7.94	0.3125	116	158	36	8	R5715/16
	8.00	0.3150	116	158	36	8	R5718.0
	8.10	0.3189	146	192	40	10	R5718.1
	8.20	0.3228	146	192	40	10	R5718.2
21/64	8.33	0.3281	146	192	40	10	R57121/64
	8.40	0.3307	146	192	40	10	R5718.4
	8.50	0.3346	146	192	40	10	R5718.5
	8.60	0.3386	146	192	40	10	R5718.6
	8.70	0.3425	146	192	40	10	R5718.7
11/32	8.73	0.3437	146	192	40	10	R57111/32
	8.80	0.3465	146	192	40	10	R5718.8
	9.00	0.3543	146	192	40	10	R5719.0
23/64	9.13	0.3594	146	192	40	10	R57123/64
	9.30	0.3661	146	192	40	10	R5719.3
	9.50	0.3740	146	192	40	10	R5719.5
3/8	9.53	0.3750	146	192	40	10	R5713/8
	9.80	0.3858	146	192	40	10	R5719.8
25/64	9.92	0.3906	146	192	40	10	R57125/64
	10.00	0.3937	146	192	40	10	R57110.0
	10.20	0.4016	176	228	45	12	R57110.2
	10.30	0.4055	176	228	45	12	R57110.3
13/32	10.32	0.4063	176	228	45	12	R57113/32
	10.40	0.4094	176	228	45	12	R57110.4
	10.50	0.4134	176	228	45	12	R57110.5
27/64	10.72	0.4219	176	228	45	12	R57127/64
	11.00	0.4331	176	228	45	12	R57111.0
7/16	11.11	0.4375	176	228	45	12	R5717/16
	11.20	0.4409	176	228	45	12	R57111.2
	11.50	0.4528	176	228	45	12	R57111.5
29/64	11.51	0.4531	176	228	45	12	R57129/64
	11.80	0.4646	176	228	45	12	R57111.8
15/32	11.91	0.4687	176	228	45	12	R57115/32
	12.00	0.4724	176	228	45	12	R57112.0

R571

d_1 Øm7 Inch	d_1 Øm ₇ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø mm	e-Code
31/64	12.30	0.4844	207	258	45	14	R57131/64
	12.50	0.4921	207	258	45	14	R57112.5
1/2	12.70	0.5000	207	258	45	14	R57111/2
	12.80	0.5039	207	258	45	14	R57112.8
	13.00	0.5118	207	258	45	14	R57113.0
33/64	13.10	0.5156	207	258	45	14	R57133/64
17/32	13.49	0.5313	207	258	45	14	R57117/32
	13.50	0.5315	207	258	45	14	R57113.5
35/64	13.89	0.5469	207	258	45	14	R57135/64
	14.00	0.5512	207	258	45	14	R57114.0
	14.25	0.5610	236	291	48	16	R57114.25
9/16	14.29	0.5625	236	291	48	16	R57119/16
	14.50	0.5709	236	291	48	16	R57114.5
37/64	14.68	0.5781	236	291	48	16	R57137/64
	15.00	0.5906	236	291	48	16	R57115.0
19/32	15.08	0.5937	236	291	48	16	R57119/32
39/64	15.47	0.6094	236	291	48	16	R57139/64
	15.50	0.6102	236	291	48	16	R57115.5

d_1 Øm7 Inch	d_1 Øm ₇ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø mm	e-Code
5/8	15.88	0.6250	236	291	48	16	R5715/8
	16.00	0.6299	236	291	48	16	R57116.0
	16.50	0.6496	266	318	48	18	R57116.5
21/32	16.67	0.6563	266	318	48	18	R57121/32
	18.80	0.6614	266	318	48	18	R57116.8
	17.00	0.6693	266	318	48	18	R57117.0
	17.50	0.6890	266	318	48	18	R57117.5
	17.80	0.7008	266	318	48	18	R57117.8
	18.00	0.7087	266	318	48	18	R57118.0
	18.50	0.7283	295	349	50	20	R57118.5
	18.80	0.7402	295	349	50	20	R57118.8
	19.00	0.7480	295	349	50	20	R57119.0
	19.50	0.7677	295	349	50	20	R57119.5
	19.80	0.7795	295	349	50	20	R57119.8
	20.00	0.7874	295	349	50	20	R57120.0

R572

- Elect APP™ Drill for deep holes
- Elect APP™-Tieflochbohrer
- Elect APP™ diepgatboren
- Foret Elect APP™ pour trous profonds
- Broca Elect APP™ para agujeros profundos
- Broca Elect APP™ para furos profundos

NEW
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R572

For pilot drilling, use R470 / Für Pilotbohrungen Typ R470 verwenden / Gebruik de R470 voor het maken van startgaten / Pour percer l'avant-trou, utiliser le foret R470 / Para agujeros piloto, utilizar R470 / Para furo guia, use R470



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
1/8	3.00	0.1181	54	96	36	6	R5723.0
	3.17	0.1250	57	99	36	6	R5721/8
	3.30	0.1299	59	101	36	6	R5723.3
9/64	3.50	0.1378	63	105	36	6	R5723.5
	3.57	0.1406	64	106	36	6	R5729/64
	3.80	0.1496	68	110	36	6	R5723.8
5/32	3.97	0.1563	71	113	36	6	R5725/32
	4.00	0.1575	72	114	36	6	R5724.0
	4.20	0.1654	76	118	36	6	R5724.2
11/64	4.37	0.1719	79	121	36	6	R57211/64
	4.50	0.1772	81	123	36	6	R5724.5
	4.76	0.1875	86	128	36	6	R5723/16
3/16	4.80	0.1890	86	128	36	6	R5724.8
	5.00	0.1969	90	132	36	6	R5725.0
	5.16	0.2031	93	135	36	6	R57213/64
7/32	5.50	0.2165	99	141	36	6	R5725.5
	5.56	0.2188	100	142	36	6	R5727/32
	5.80	0.2283	104	146	36	6	R5725.8
15/64	5.95	0.2344	107	149	36	6	R57215/64
	6.00	0.2362	108	150	36	6	R5726.0
	6.35	0.2500	114	156	36	8	R5721/4
1/4	6.50	0.2559	117	159	36	8	R5726.5
	6.75	0.2656	121	163	36	8	R57217/64
	6.80	0.2677	122	164	36	8	R5726.8
17/64	7.00	0.2756	126	168	36	8	R5727.0
	7.14	0.2813	129	171	36	8	R5729/32

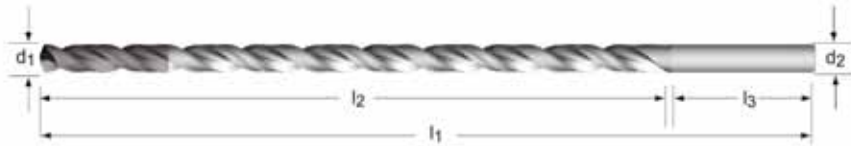
d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
19/64	7.50	0.2953	135	177	36	8	R5727.5
	7.54	0.2969	136	178	36	8	R57219/64
	7.80	0.3071	140	182	36	8	R5727.8
5/16	7.94	0.3125	143	185	36	8	R5725/16
	8.00	0.3150	144	186	36	8	R5728.0
	8.33	0.3281	150	202	40	10	R57221/64
21/64	8.50	0.3346	153	205	40	10	R5728.5
	8.73	0.3437	157	209	40	10	R57211/32
	9.00	0.3543	162	214	40	10	R5729.0
23/64	9.13	0.3594	164	216	40	10	R57223/64
	9.50	0.3740	171	223	40	10	R5729.5
	9.53	0.3750	171	223	40	10	R5723/8
3/8	9.80	0.3858	176	228	40	10	R5729.8
	9.92	0.3906	179	231	40	10	R57225/64
	10.00	0.3937	180	232	40	10	R57210.0
13/32	10.30	0.4055	185	237	45	12	R57210.3
	10.32	0.4063	186	238	45	12	R57213/32
	10.50	0.4134	189	241	45	12	R57210.5
27/64	10.72	0.4219	193	245	45	12	R57227/64
	11.00	0.4331	198	250	45	12	R57211.0
	11.11	0.4375	200	252	45	12	R5727/16
7/16	11.50	0.4528	207	259	45	12	R57211.5
	11.51	0.4531	207	259	45	12	R57229/64
	11.80	0.4646	212	264	45	12	R57211.8
29/64	12.00	0.4724	216	268	45	12	R57212.0

R573

- Elect APP™ Drill for deep holes
- Elect APP™-Tieflochbohrer
- Elect APP™ diepgatboren
- Foret Elect APP™ pour trous profonds
- Broca Elect APP™ para agujeros profundos
- Broca Elect APP™ para furos profundos

NEW

2010.09



R573

For pilot drilling, use R470 / Für Pilotbohrungen Typ R470 verwenden / Gebruik de R470 voor het maken van start-gaten / Pour percer l'avant-trou, utiliser le foret R470 / Para agujeros piloto, utilizar R470 / Para furo guia, use R470



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
1/8	3.00	0.1181	69	111	36	6	R5733.0
	3.17	0.1250	73	115	36	6	R5731/8
	3.30	0.1299	76	118	36	6	R5733.3
9/64	3.50	0.1378	80	122	36	6	R5733.5
	3.57	0.1406	82	124	36	6	R5739/64
	3.80	0.1496	87	129	36	6	R5733.8
5/32	3.97	0.1563	91	133	36	6	R5735/32
	4.00	0.1575	92	134	36	6	R5734.0
	4.20	0.1654	97	139	36	6	R5734.2
11/64	4.37	0.1719	100	142	36	6	R57311/64
	4.50	0.1772	103	145	36	6	R5734.5
	4.76	0.1875	110	152	36	6	R5733/16
3/16	4.80	0.1890	110	152	36	6	R5734.8
	5.00	0.1969	115	157	36	6	R5735.0
	5.16	0.2031	119	161	36	6	R57313/64
7/32	5.50	0.2165	126	168	36	6	R5735.5
	5.56	0.2188	128	170	36	6	R5737/32
	5.80	0.2283	133	175	36	6	R5735.8
15/64	5.95	0.2344	137	179	36	6	R57315/64
	6.00	0.2362	138	180	36	6	R5736.0
	6.35	0.2500	146	188	36	8	R5731/4
1/4	6.50	0.2559	149	191	36	8	R5736.5
	6.75	0.2656	155	197	36	8	R57317/64
	6.80	0.2677	156	198	36	8	R5736.8
17/64	7.00	0.2756	161	203	36	8	R5737.0
	7.14	0.2813	164	206	36	8	R5739/32

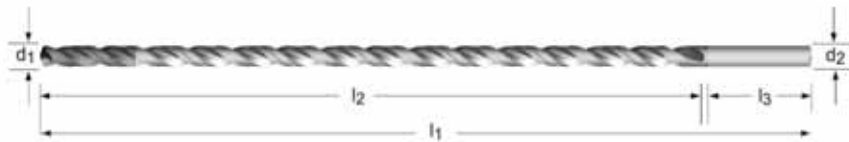
d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
19/64	7.50	0.2953	172	214	36	8	R5737.5
	7.54	0.2969	173	215	36	8	R57319/64
	7.80	0.3071	179	221	36	8	R5737.8
5/16	7.94	0.3125	183	225	36	8	R5735/16
	8.00	0.3150	184	226	36	8	R5738.0
	8.33	0.3281	192	238	40	10	R57321/64
21/64	8.50	0.3346	195	241	40	10	R5738.5
	8.73	0.3437	201	247	40	10	R57311/32
	9.00	0.3543	207	253	40	10	R5739.0
23/64	9.13	0.3594	210	256	40	10	R57323/64
	9.50	0.3740	218	264	40	10	R5739.5
	9.53	0.3750	219	265	40	10	R5733/8
3/8	9.80	0.3858	225	271	40	10	R5739.8
	9.92	0.3906	228	274	40	10	R57325/64
	10.00	0.3937	230	276	40	10	R57310.0
13/32	10.30	0.4055	237	291	45	12	R57310.3
	10.32	0.4063	237	291	45	12	R57313/32
	10.50	0.4134	241	295	45	12	R57310.5
27/64	10.72	0.4219	246	300	45	12	R57327/64
	11.00	0.4331	253	307	45	12	R57311.0
	11.11	0.4375	256	310	45	12	R5737/16
7/16	11.50	0.4528	264	318	45	12	R57311.5
	11.51	0.4531	265	319	45	12	R57329/64
	11.80	0.4646	271	325	45	12	R57311.8
29/64	12.00	0.4724	276	330	45	12	R57312.0

R575

- Elect APP™ Drill for deep holes
- Elect APP™-Tieflochbohrer
- Elect APP™ diepgatboren
- Foret Elect APP™ pour trous profonds
- Broca Elect APP™ para agujeros profundos
- Broca Elect APP™ para furos profundos

NEW

2010.09



R575

For pilot drilling, use R470 / Für Pilotbohrungen Typ R470 verwenden / Gebruik de R470 voor het maken van startgaten / Pour percer l'avant-trou, utiliser le foret R470 / Para agujeros piloto, utilizar R470 / Para furo guia, use R470



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
1/8	3.00	0.1181	99	141	36	6	R5753.0
	3.17	0.1250	105	147	36	6	R5751/8
	3.50	0.1378	115	157	36	6	R5753.5
9/64	3.57	0.1406	118	160	36	6	R5759/64
5/32	3.97	0.1563	131	173	36	6	R5755/32
	4.00	0.1575	132	174	36	6	R5754.0
11/64	4.37	0.1719	144	186	36	6	R57511/64
	4.50	0.1772	148	190	36	6	R5754.5
3/16	4.76	0.1875	157	199	36	6	R5753/16
	5.00	0.1969	165	207	36	6	R5755.0
13/64	5.16	0.2031	170	212	36	6	R57513/64
	5.50	0.2165	181	223	36	6	R5755.5

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
7/32	5.56	0.2188	183	225	36	6	R5757/32
15/64	5.95	0.2344	196	238	36	6	R57515/64
	6.00	0.2362	198	240	36	6	R5756.0
1/4	6.35	0.2500	210	252	36	8	R5751/4
	6.50	0.2559	214	256	36	8	R5756.5
17/64	6.75	0.2656	223	265	36	8	R57517/64
	7.00	0.2756	231	273	36	8	R5757.0
9/32	7.14	0.2813	236	278	36	8	R5759/32
	7.50	0.2953	247	289	36	8	R5757.5
19/64	7.54	0.2969	249	291	36	8	R57519/64
5/16	7.94	0.3125	262	304	36	8	R5755/16
	8.00	0.3150	264	306	36	8	R5758.0

R470

- Pilot Drill for Elect APP™ deep hole drills
- Foret guide pour foret Elect APP™ pour trous profonds
- Pilotbohrer für Elect APP™-Tieflochbohrer
- Brocas piloto para brocas Elect APP™ para agujeros profundos
- Startgatboren voor Elect APP™ diepgatboren
- Brocas guia para Brocas Elect APP™ para furação profunda



R470

For use with R572, R573, R575 / Für den Einsatz mit R572, R573, R575 / Voor gebruik met de R572, R573, R575 / Utiliser avec les forets R572, R573, R575 / Para utilizar con R572, R573, R575 / Para uso com R572, R573, R575



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1
- 7.2 7.3 7.4
- 2.3 2.4

d ₁ Øp ₇ Inch	d ₁ Øp ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
	3.00	0.1181	20	62	36	6	R4703.0
1/8	3.17	0.1250	20	62	36	6	R4701/8
	3.30	0.1299	20	62	36	6	R4703.3
	3.50	0.1378	20	62	36	6	R4703.5
9/64	3.57	0.1406	20	62	36	6	R4709/64
	3.80	0.1496	24	66	36	6	R4703.8
5/32	3.97	0.1563	24	66	36	6	R4705/32
	4.00	0.1575	24	66	36	6	R4704.0
	4.20	0.1654	24	66	36	6	R4704.2
11/64	4.37	0.1719	24	66	36	6	R47011/64
	4.50	0.1772	24	66	36	6	R4704.5
3/16	4.76	0.1875	28	66	36	6	R4703/16
	4.80	0.1890	28	66	36	6	R4704.8
	5.00	0.1969	28	66	36	6	R4705.0
13/64	5.16	0.2031	28	66	36	6	R47013/64
	5.50	0.2165	28	66	36	6	R4705.5
7/32	5.56	0.2188	28	66	36	6	R4707/32
	5.80	0.2283	28	66	36	6	R4705.8
15/64	5.95	0.2344	28	66	36	6	R47015/64
	6.00	0.2362	28	66	36	6	R4706.0
1/4	6.35	0.2500	34	79	36	8	R4701/4
	6.50	0.2559	34	79	36	8	R4706.5
17/64	6.75	0.2656	34	79	36	8	R47017/64
	6.80	0.2677	34	79	36	8	R4706.8
	7.00	0.2756	34	79	36	8	R4707.0
9/32	7.14	0.2813	41	79	36	8	R4709/32

d ₁ Øp ₇ Inch	d ₁ Øp ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	e-Code
	7.50	0.2953	41	79	36	8	R4707.5
19/64	7.54	0.2969	41	79	36	8	R47019/64
	7.80	0.3071	41	79	36	8	R4707.8
5/16	7.94	0.3125	41	79	36	8	R4705/16
	8.00	0.3150	41	79	36	8	R4708.0
21/64	8.33	0.3281	47	89	40	10	R47021/64
	8.50	0.3346	47	89	40	10	R4708.5
11/32	8.73	0.3437	47	89	40	10	R47011/32
	9.00	0.3543	47	89	40	10	R4709.0
23/64	9.13	0.3594	47	89	40	10	R47023/64
	9.50	0.3740	47	89	40	10	R4709.5
3/8	9.52	0.3750	47	89	40	10	R4703/8
	9.80	0.3858	47	89	40	10	R4709.8
25/64	9.92	0.3906	47	89	40	10	R47025/64
	10.00	0.3937	47	89	40	10	R47010.0
	10.30	0.4055	55	102	45	12	R47010.3
13/32	10.32	0.4063	55	102	45	12	R47013/32
	10.50	0.4134	55	102	45	12	R47010.5
27/64	10.72	0.4219	55	102	45	12	R47027/64
	11.00	0.4331	55	102	45	12	R47011.0
7/16	11.11	0.4375	55	102	45	12	R4707/16
	11.50	0.4528	55	102	45	12	R47011.5
29/64	11.51	0.4531	55	102	45	12	R47029/64
	11.80	0.4646	55	102	45	12	R47011.8
	12.00	0.4724	55	102	45	12	R47012.0

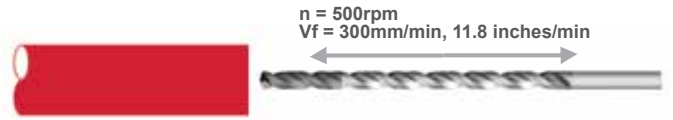
Drilling Hints and Tips

with Elect APP™ drills for deep holes

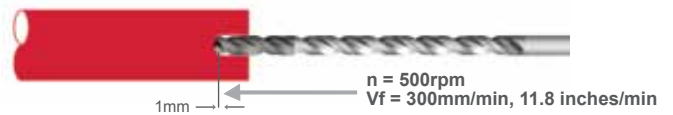
Deep hole drilling with pilot hole (>12 x Ø only)

Do not move the drill at greater than 500rpm and 300mm/min when outside a pilot hole.

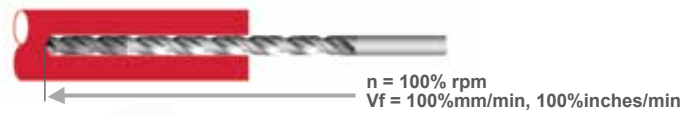
1) Pilot drill 1.5 x Ø.



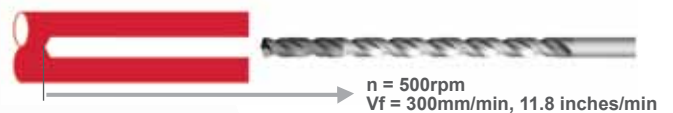
2) Engage deep hole drill at low speed/feed (500rpm and 300mm/min) to 1mm above depth of pilot.



3) Turn on coolant (min 20 bar), recommended speed and feed to full depth - no pecking required.



4) Remove drill at low speed and feed (500rpm and 300mm/min).



R470 - Pilot Drill

Deep hole drilling with cross hole

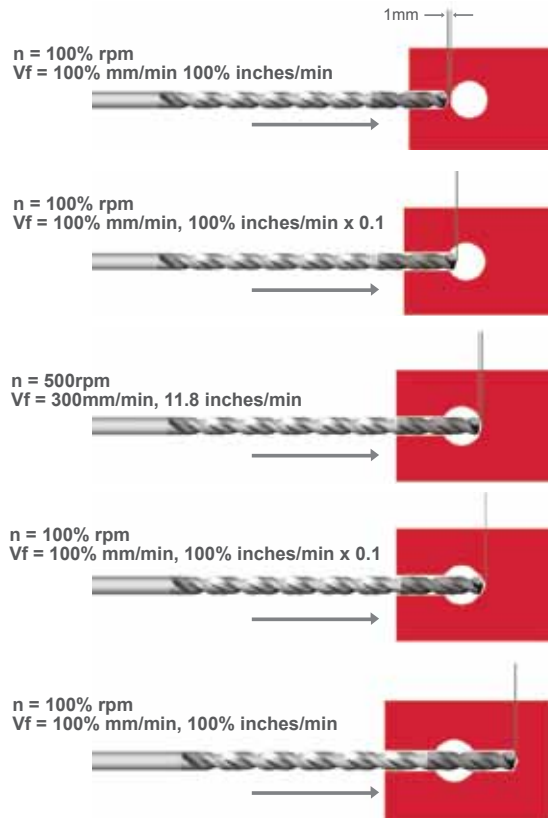
Drill at recommended speed and feed until 1mm from cross hole.

Break into cross hole at recommended speed and with recommended feed x 0.1.

When outer corners of the drill have fully entered cross hole, use 500rpm and 300mm/min to move across the hole.

Stop before drill comes into contact with opposite surface, then use recommended speed and 0.1 x recommended feed.

When outer corners of the drill are fully engaged, use recommended speed and feed to continue drilling.

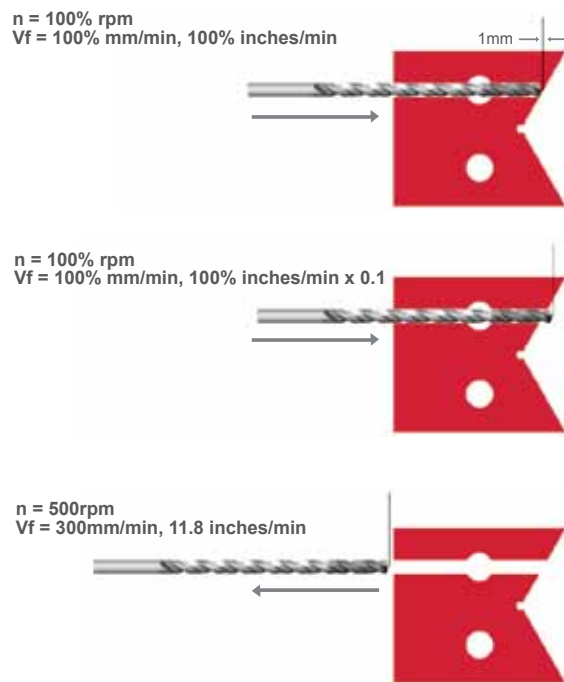


Deep hole drilling exit on angled face

Drill at recommended speed and feed until 1mm from angled face.

Break across angled face at recommended speed and with 0.1 x recommended feed.

When outer corners of drill have fully cleared angled face, retract at 500rpm and 300mm/min.



For other applications in deep hole drilling, please contact your Dormer technical sales representative.

DORMER

The Right Tool at the Right Time



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